

Work Order ID 60699

Monday, July 19, 2010 2:38:25 PM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 7/19/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 8/5/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *R*

Date: 10-7-19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2580

Rev D

100



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

0.00

0.00

110



CNC Bend 1

CNC Delta 100 Bender

BENDING MACHINE - SKIDTUBES

Memo

1-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube

0.00

0.00

10-7-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval. QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DOA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Revision ID:

Stop



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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Pro-7

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D205-634-041 PAR #: Fault Category: Skid tubes NCR: Yes No DQA: Date: 10/7/29
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: Date: 10/08/04

NCR: <u>60699</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/7/23	# BD	Found that APT end of tube was crushed and APT cap would not fit. 2 trying to fit APT cap I (E. Downing) cracked the	<u> </u> 10/08/04	Scrap & destroy the tube.	<u>BE</u> 10/08/04	<u> </u> 10-8-4	<u> </u> 10/07/29	<u>S</u> 10/07/23
		tube roughly about 3/4" in length along the outside edge at the APT end of tube. E.C. human error /	<u> </u> 10/08/04					<u>S</u> 10/07/23
		incompetence L.O.A. R.C. of part crushing is process.	<u> </u> 10/08/04					<u>S</u> 10/07/23

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

0.00

Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R□□□ Aluminum Rod

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill
A/R□□□ Aluminum Rod

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",
adjust stopper not to hit web. Deburr5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580.
Deburr holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item Name: Replacement Skidtube

Start Date: 7/19/2010 Start Qty: 1.00




Required Date: 8/5/2010 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	QC10- Inspect visual per QSI004- ground welds	0.00							
QC Quality Control	Memo	0.00							
160 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00							
170 	Pressure Wash per QSI005 4.3	0.00							
HandFinish Hand Finishing	Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.	0.00							

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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[illegible]

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Accept

Setup Start

Stop

**Cust Item ID:**[illegible]

Customer:

Reference:

Run Start

Abstract

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID

Tool #**Plan
Code**

Accept
Qty

Reject
QtyReject
Number

**Insp.
Stamp**

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

[illegible]

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

190

QC3- Inspect Part Finish

0.00

[illegible]

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Item ID: D205-634-041

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Item Name: Replacement Skidtube

Start Date: 7/19/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 8/5/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R ☐ ☐ ☐ Sikaflex-291 ☐ _____ ☐ ☐ ☐

Sikaflex expire date: _____

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R ☐ ☐ ☐ Sikaflex-291 ☐ _____ ☐ ☐ ☐

Sikaflex expire date: _____

5-Wing Walk as per Dwg D2580 and QSI 005 4.4
Batch: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 7/19/2010 Start Qty: 1.00

Required Date: 8/5/2010 Req'd Qty: 1.00

Reference:




Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Setup Start

Stop

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024	0.00							
220 	Packaging	0.00							
Packaging Packaging	Memo Identify and pack for shipping as per PPPD205-634-041 Location: _____ PPP Rev: _____	0.00							
230 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

ME
10-8-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 60699



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 7/19/2010

Required Date: 8/5/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
 IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2580-1

Manufactured

No

110

Each

6.0000

1

1



205 Skidtube bent detail

Location

Loc Qty

Loc Code

LG

4

57028

1

59297

1

60379

2

ST046

2

59913

2

①

DP 10-7-22

D2576-3

Manufactured

No

140

Each

90.0000

1

1



Step (maching detail)

Location

Loc Qty

Loc Code

LG

90

46661

42

52215

48

D2579

Manufactured

No

140

Each

313.0000

20

20



Crossbolt Spacer

Location

Loc Qty

Loc Code

LG

313

57052

5

57348

4

58433

14

59113

290

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 2

Work Order ID: 60699

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 7/19/2010

Required Date: 8/5/2010

Start Qty: 1.00

Required Qty: 1.00

D2855 Manufactured No 200 Each

83.0000 1 1



Cap

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP6	1	
56613	1	
ST026	82	
50513	1	
50770	28	
51539	2	
53791	51	

AN3-5A Purchased No 200 Each

1,128.000 2 2



Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST350	1128	
105057	628	
115016	500	

AN960JD10L NAS1149D0332J Purchased No 200 Each

3,077.000 2 2



Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST348	3077	
110985	3077	

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DOA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 60699

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 7/19/2010

Required Date: 8/5/2010

Start Qty: 1.00

Required Qty: 1.00

ALS7-1032-130 Purchased No

200 Each

950.0000 50 50



Insert

Location

Loc Qty

Loc Code

FP 933

115079 933

ST282 17

113238 17

AN3C4A Purchased No

200 Each

1,533.000 50 50



BOLT

Location

Loc Qty

Loc Code

ST350 1533

114103 501

114108 14

114416 12

114523 2

114859 4

114941 1000

AN960C10L NAS1149C0332 Purchased No

200 Each

0.0000 50 50



washer

D3566-13 Manufactured No

200 Each

36.0000 1 1



Gasket

Location

Loc Qty

Loc Code

FP 5

53461 5

FP012 31

59661 23

60209 8

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Page 3

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 4

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Parent Item Name: Replacement Skidtube

Start Date: 7/19/2010

Required Date: 8/5/2010


Start Qty: 1.00

Required Qty: 1.00

D3566-5

 Gasket


Manufactured No 200 Each 17.0000 1 1

Location	Loc Qty	Loc Code
FP015	17	
59158	17	

D3566-1

 Gasket


Manufactured No 200 Each 23.0000 2 2

Location	Loc Qty	Loc Code
FP015	23	
57715	2	
59126	9	
60202	12	

D3564-11

 Wearshoe

Manufactured No 200 Each 10.0000 1 1

Location	Loc Qty	Loc Code
FP019	10	
59941	10	

D3564-13

 Wearshoe

Manufactured No 200 Each 20.0000 1 1

Location	Loc Qty	Loc Code
FP17	20	
57922	1	
59660	19	

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DCA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 60699



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 7/19/2010

Required Date: 8/5/2010

Start Qty: 1.00

Required Qty: 1.00

D3564-9 Manufactured No 200 Each



Wearshoe

13.0000 1 1



Location

Loc Qty

Loc Code

FP 1

55334 1

FP019 12

59201 12

D3564-5 Manufactured No 200 Each



Wearshoe

17.0000 1 1



Location

Loc Qty

Loc Code

FG 1

34806 1

FP19 5

57525 1

58709 4

FP-19 11

59157 11

D2594-3 Manufactured No 200 Each



O-Ring, 205 Skidtube

443.0000 16 16



Location

Loc Qty

Loc Code

FP 443

55546 19

58191 12

59358 412

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Replacement Skidtube

Start Date: 7/19/2010

Required Date: 8/5/2010

Start Qty: 1.00

Required Qty: 1.00

D2594-1

Manufactured No

200

Each

451.0000

16

16



Plug, 205 Skidtube



Location

Loc Qty

Loc Code

FP

183

42807

112

55002

71

FP14

268

58434

79

59110

189

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W/O:		WORK ORDER CHANGES						
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DART

DESIGN #	DRAWN BY RH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07-06-28 #

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

SHOP COPY

RETURN TO

FURNISHING

UNCONTROLLED COPY

SUBJECT TO ASSESSMENT

WITHOUT NOTICE

WORK ORDER

NO. 006999

210-779

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
07-06-28

Diagram illustrating the grinding locations on the propeller cross-section:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- LOCATION RIDGE ON UNDERSIDE OF D2576
- GRIND FLUSH

D2579 SPACER

WEB (REF)

170 (REF)

AFTER PERFO

1. CHA
2. INS
3. WE

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C-BORE D2579 SPACER TO #0.437 X 1.00 DEEP

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

[illegible]

WELD AS PER DETAIL B

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

REFER TO DETAIL C

D3566-1, **D3566-5**, **D3566-1**, **D3566-13**

D3564-11, **D3564-5**, **D3564-9**, **D3564-13**

AN304A BOLT (1)
AN960C10L WASHER (1)
(50 PLACES)

DESIGN / **DRAWN BY**

W/060699

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DRAWN BY

APPROVED

07.02.27

DART

DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D2580

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205 SKIDTUBE ASSEMBLY

REV D

SHEET 2 OF 3

SCALE

100

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

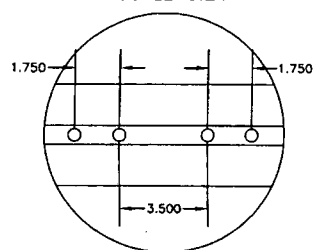
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

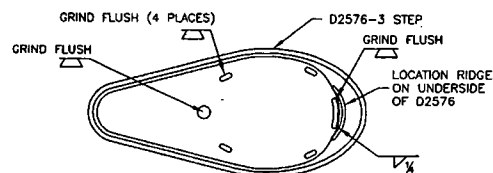
NOTE: Date & initial all entries

DETAIL E
SCALE 5:24

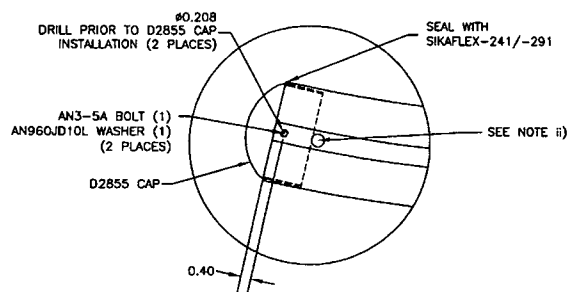


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07.06.28

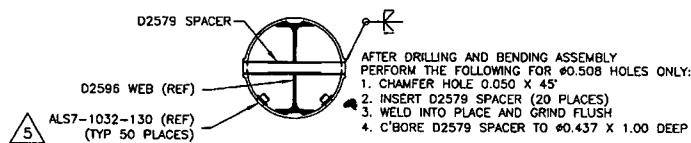
DETAIL F
SCALE 5:24



DETAIL G
SCALE 5:24



SECTION H-H
SCALE 5:24

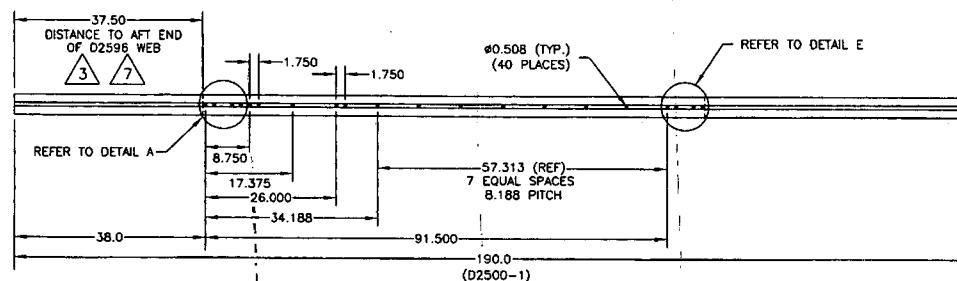


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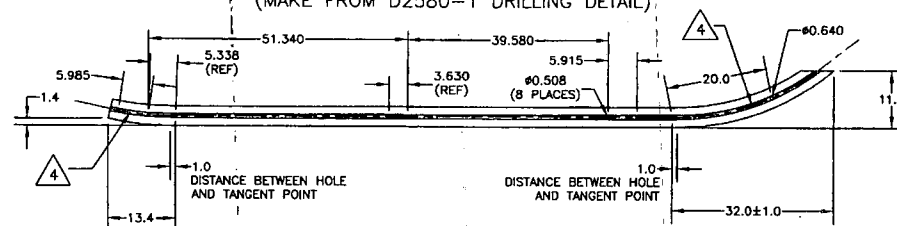
D2580-045 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

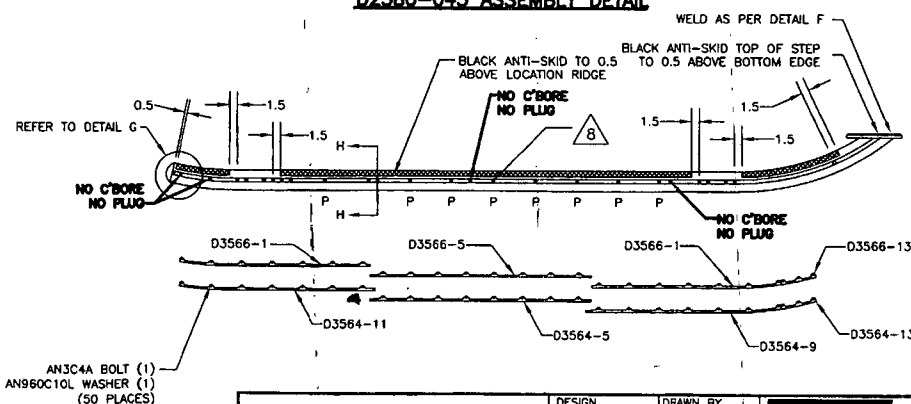
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



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CHECKED <i>W</i>	APPROVED <i>W</i>	DRAWING NO. D2580	REV. D SHEET 3 OF 3
DATE 07.02.27	TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries